

Date: Thursday, 5/4/2006 11:13:45 AM  
 User: Kim Johnston

## Process Sheet

*split*  
*SB 06/06/15*

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 26954  
 Estimate Number : 12186  
 P.O. Number : *NIA*  
 This Issue : 5/4/2006 S.O. No. : *NIA*  
 Prsht Rev. : NC  
 First Issue : *NIA* Type : SMALL /MED FAB  
 Previous Run : 26482  
 Drawing Name : SHUT-OFF VALVE ASSEMBLY  
 Part Number : D3469041  
 Drawing Number : D3469 REV A1  
 Project Number : N/A  
 Drawing Revision : A1  
 Material : *NIA*  
 Due Date : 5/28/2006 Qty: 8 Um: Each  
 Written By : *SPK*  
 Checked & Approved By : *OK 06.05.05*  
 Comment : Est Rev: A New Issue 06-02-03 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D3469043 TUBE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D3469-408 Tube Assembly *B 26985*

*043*

2.0 D3470041 SHUT-OFF VALVE SHAFT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D3470-041 Shut-Off Valve Assembly *B 3470 041*

*26986*

3.0 D34705 PLATE VALVE



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 4 D3470-5 Plate Valve *B 26116*

4.0 D34707 valve seal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 2 D3470-7 Valve Seal *B 26988*



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 26954

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34709

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: B 26387

6.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	<u>M19356</u>

7.0

AN9604L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

*306.06.1A*  
Qty Part Number Description Batch

4 AN960-4L

Washer

M14606

8.0

AN960416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-416

Washer

M5519

9.0

MS24665153

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

COTTER PIN

Batch: M19096

10.0

MS35206217

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS35206-217

Screw

M13883





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 26954

Part Number: D3469041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 NAS679A04 NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS679-A04 Nut

*M100551*

*FF 06-06-14*

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469

*SB 04/06/15*

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure Unit Opens and Closes Smoothly

*Doc 06-150*

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location:

*Pack 4/15*

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/16*

Job Completion

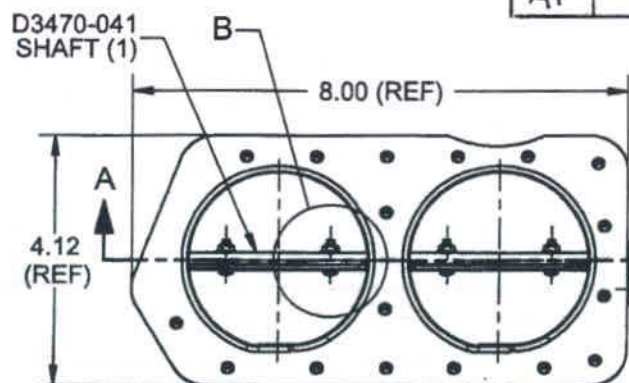


*u 06-06-16*



**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3469</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.12</b>		TITLE <b>SHUT-OFF VALVE ASS'Y</b>	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED BOM ON PAGE 2	

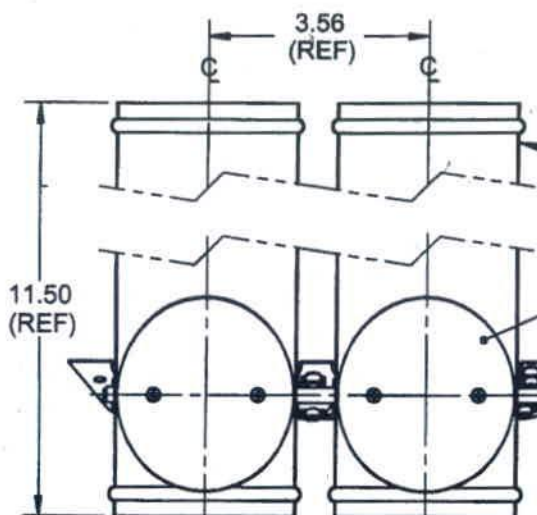


MS35206-217 SCREW  
AN960-4L WASHER  
NAS679-A04 NUT  
(4 PLACES)

D3470-7  
BUTTERFLY  
VALVE SEAL  
(2 PLACES)

MS24665-153  
COTTER PIN (1)

**DETAIL B**  
**SCALE 1:1**



**SECTION A-A**

**D3469-041 SHUT-OFF VALVE ASS'Y**

**NOTES:**

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

